

**Work Order ID 70722**

Monday, June 13, 2011 3:23:18 PM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 6/13/2011 Start Qty: 2.00

Required Date: 6/20/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3852	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

- 1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig
- 2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852
- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr
- 6- weld D3759-1 bushing as per dwg D3852  
A/R ER316 S.S. Rod Batch: 115928
- 7- grind bushing weld flush as per dwg dwg D3852
- 8- deburr hole if necessary

SAO 11-07-04

Cpl 11-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 70722

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Page 2

Item ID: D3852-041

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Revision ID:

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Item Name: Rib Assembly

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Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QS1004- ground welds  Memo	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>B/c</u>  Memo	0.00 0.00							

*8 units loc*

*8 units loc*

*(x6)*  
*-041*

*6/11-07.04*

W/O:		WORK ORDER CHANGES					
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**Work Order ID 70722**

Monday, June 13, 2011 3:23:18 PM



Page 3

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 6/13/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/6 98

11-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, June 13, 2011 3:23:26 PM

Page 1

Work Order ID: 70722

Parent Item: D3852-041

Parent Item Name: Rib Assembly



Start Date: 6/13/2011

Required Date: 6/20/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3 Basket Hoop		Manufactured	No			100	Each	4.0201	0.18	<del>0.378947</del> SFA	1.137	11-07-04	
------------------------	--	--------------	----	--	--	-----	------	--------	------	----------------------------	-------	----------	--

M304TS0.750W.065

Location

Loc Qty

Loc Code

B116763 → 1.137

WA007

4.02010527

64928

0.02010527

68442

4

D3759-1



Bushing

Manufactured

No

100

Each

311.0000

1

2

PC 11.007.05

Location

Loc Qty

Loc Code

WA

200

69202

200

WA005

111

66489

2

66870

109

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

**D3852-041 RIB ASSEMBLY**

**D3852-042 RIB ASSEMBLY**

SHOP ONLY  
RETURNED  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70722

*11-06-13*

RELEASE  
*08/11/07 MP*

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.83 lbs EACH  
8) WELDING: PER QSI 004

REV.	NEW ISSUE	DESCRIPTION	MB	08.11.07
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.07			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSEMBLY** SCALE NTS

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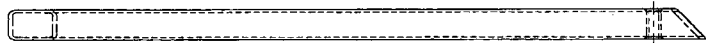
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

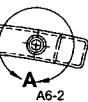
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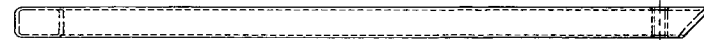


D3852-1  
RIB

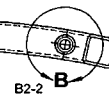


A6-2

**D3852-041 RIB ASSEMBLY**



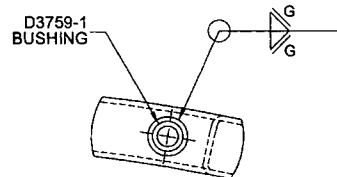
D3852-2  
RIB



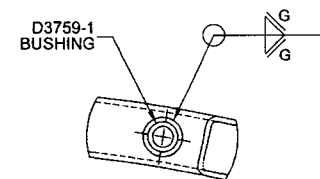
B2-2

**D3852-042 RIB ASSEMBLY**

u/o 70722



**DETAIL A**  
SCALE 2X C5-2



**DETAIL B**  
SCALE 2X C2-2

**RELEASED**  
08/11/07

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	125	DRAWING NO. D3852	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
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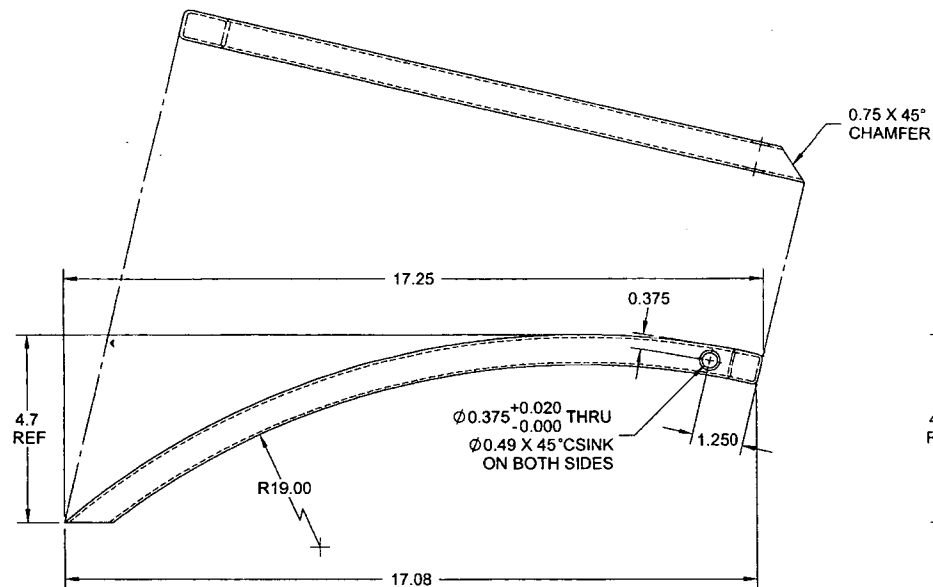
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

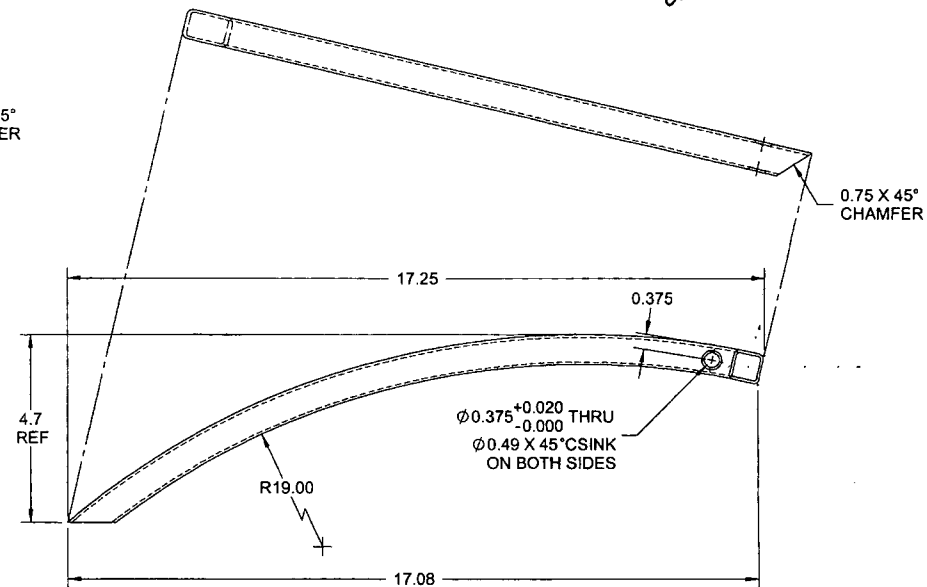
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**NOTE:** Date & initial all entries

*u/b 70727*



**D3852-1 RIB**



**D3852-2 RIB**

**RELEASED**  
*08/11/07*

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.82 lbs EACH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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